

Work Order ID 129341

Wednesday, February 04, 2015 9:59:19 AM

ASAP

129341

~~PRELIMINARY ISSUE~~

Page 1

Item ID: D5159-1

Revision ID: PRELIM

Item Name: Rib



Accept

N900040100

Setup Start

NS1

Stop

NS2

Start Date: 2/4/2015

Start Qty: 16.00

16

Cust Item ID:

Required Date: 2/4/2015

Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

MLS

Date: 15-02-04

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D5159

001

REVA JPM

110

0.00

110

Cold Saw

Memo

0.00

Hyd Mech

CUT TO BLANK

16

0

J.C.L

120

Manufacture as per dwg

0.00

120

Mill Conv

Memo

0.00

Conventional Milling Machine

DRILL HOLES AND MILL ENDS AS PER DWG

14

2

DAS

37

9-89 15.02.12

130

QC2- Inspect parts off machine FAI/FAIB

0.00

130

QC

Memo

0.00

Quality Control

14

2

DAS

37

9-89 15.02.12

DQA: dat Date: 15/04/01



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: RPM Date: 15/04/01

Work Order update only ☐

Work Order: <u>1a9341</u> Part No: <u>25189-1</u> NCR No: <u>15-4767</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	15.02.12	120	2	DRILL DEFLECTED ON THE SEAM CAUSING THE .375 DIMENSION TO BE OUT OF TOLERANCE. DIMENSION MEASURING AT .404.	DAS 37	Scrap & destroy no replace	DAS 37 9-89 15.02.12		DAS 9-89 15.02.12
Doc/Data									
Equip/Tooling	☒								
Handling/Pre	☐								
Material	☒								
Operator	☒								
Offset/Setup	☐								
Process	☒								
Supplier	☐								
Training	☐								
Transport	☐								
Unapproved	☐								

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☒ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☒ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

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Accept

N900040100

Setup Start

NS1

Revision ID: PRELIM

Stop

NS2

Item Name: Rib

Start Date: 2/4/2015

Start Qty: 16.00

16

Cust Item ID:

Required Date: 2/4/2015

Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC8- Inspect parts - second check

0.00

140

QC

Memo

0.00

Quality Control

DAS
40
9-89

15/02/12

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

150

Powdercoat

11128564.

Memo

0.00

Powder Coating

START TIME: 1:10.

OVEN TEMPERATURE: 320°

FINISH TIME: 1:40.

14/02/15-2-18. DAS 40 9-89

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

(14) 15-02-19.

DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 129341

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Page 3

Item ID: D5159-1

Accept

N900040100

Setup Start

NS1

Revision ID: PRELIM

Stop

NS2

Item Name: Rib

Start Date: 2/4/2015 Start Qty: 16.00

16

Cust Item ID:

Required Date: 2/4/2015 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: GA

0.00

170

Packaging

Memo

0.00

DAS
30
9-89

14

15/02/19

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

15/2/2019

POSITIVE RECALL

EFFECTIVE 15-02-04 AUTH MLS

RELEASED DATE

ME
15-2-20

DQA: _____ Date: _____



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Material									
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Offset/Setup									
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Wednesday, February 04, 2015 9:59:23 AM

Work Order ID: 129341

Parent Item: D5159-1

Parent Item Name: Rib

129341

D5159-1

~~PRELIMINARY ISSUE~~

Page 1

Start Date: 2/4/2015

Required Date: 2/4/2015

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A 14.10.03 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TS0.750W.049

Purchased

No

f

1,170.160

21

M304TS0 750W 049

304 SQ Tube .75x.75x.049W

**

J.C.L 15/01/04

Location

WA004

Loc Qty

1170.16

M130010

6.16

M130871

564

M131128

600

Loc Code

19.833

DQA: _____ Date: _____



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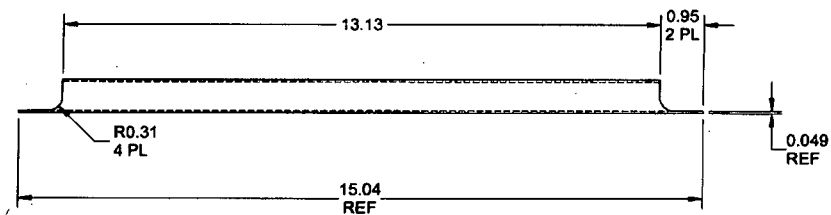
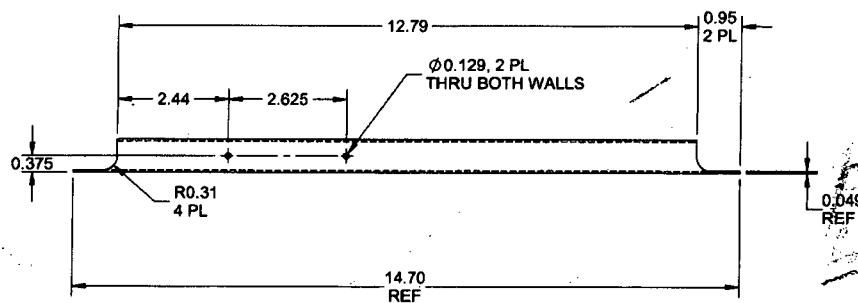
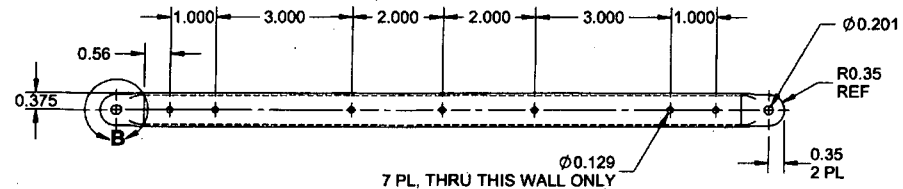
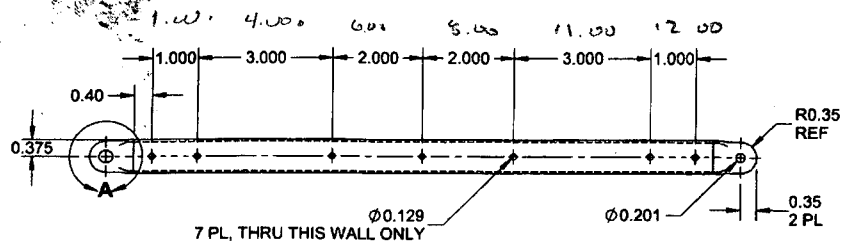
1000

1000

1000

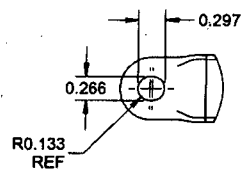
1000

1000

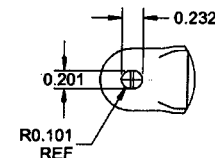


D5159-1 RIB

D5159-3 SEAT RIB



DETAIL A
SCALE 2X



DETAIL B
SCALE 2X

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
PER ASTM A554/A289 MILL FINISH
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.49 lbs
-3: 0.50 lbs

RELEASED

2015 FEB 04

APPROVED

DESIGN	AJS
DRAWN	AJS
CHECKED	AP
MFG. APPR.	DD
APPROVED	HS
DE APPR.	DS
DATE	14.09.24

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D5159** REV. A
SHEET 3 OF 3
TITLE **SEAT BRACE ASSY** SCALE NTS

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